

Date: Tuesday, 5/23/2006 8:31:17 AM
User: Kim Johnston

Process Sheet

SPLIT-2

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BLADE		
Job Number	: 27186		Part Number	: D2741		
Estimate Number	: 10327		Drawing Number	: D2741 REV C		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	5/23/2006	S.O. No. : N/A	Drawing Revision	: C		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 6/15/2006		
Previous Run	: 25938		Qty:	30	Um:	Each
Written By	: <u>See Fragment Below</u>					
Checked & Approved By	: <u>ML 06-05-23</u>					
Comment	Est Rev: B 06-11-15 Removed P/O turning - in house processEC Est Rev: E 06-03-20 As Per Rev C JLM Est Rev: F 06-04-20 Added grinding after heat treating EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M4130NB0500X03000	4130 Bar 0.5 x 3.0"	 <i>ML 06/05/27 24</i>
Comment: Qty.: 1.2118 f(s)/Unit Total : 36.3542 f(s) 4130 BAR 0.5 x 3.0" Material: 4130 steel bar 0.50" x 3.00" Batch: <u>1100310</u>			
2.0	BAND SAW	BAND SAW	 <i>ML 06/05/27 24</i>
Comment: BAND SAW Cut blanks 13.850" long +0.063" -0.000"			
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	 <i>ML 06/05/27 24</i>
Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine per folio FA108			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 5/23/2006 8:31:17 AM
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SLIP

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE

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Job Number:



Seq. #: Machine Or Operation:

Description :

4.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mf 06/05/29 24

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

MS 06/06/06 24

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

FF 06/07/13 24

1-Deburr

2-Bend per Dwg D2741

SB 06/07/12 24

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Job 06.07.13 24

8.0 PG

PURCHASING



Comment: PURCHASING

Issue P/O: 1678

c 06/07/13

Harden material as per Dwg D2741

Min. Ultimate Tensile Strength = 152 ksi (30-40 HRC)

(24)

Min. Yield Tensile Strength = 141 ksi

Test report or Certification required

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive and Inspect for transit damage

Ensure Test report or Certification attached

06/07/28 (24)

10.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Job 06.08.02 24

11.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Grind off carbon deposits

m.f. 06/08/02 24

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

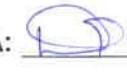
Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

No

DQA: 

Date: 06/08/04

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Date: Tuesday, 5/23/2006 8:31:17 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE

Job Number: 27186

Part Number: D2741

Job Number:



Seq. #:	Machine Or Operation:	Description :
12.0	POWDER COATING	POWDER COATING
	Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3	a.m. 06-08-03 (24)
13.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	10/8/03 24
14.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ST150	LB-06/08/03 (24)
15.0	DC	DOCUMENT CONTROL
	Comment: DOCUMENT CONTROL Inspection Level 21	06/08/04 (24)

Job Completion



c 06/08/04

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

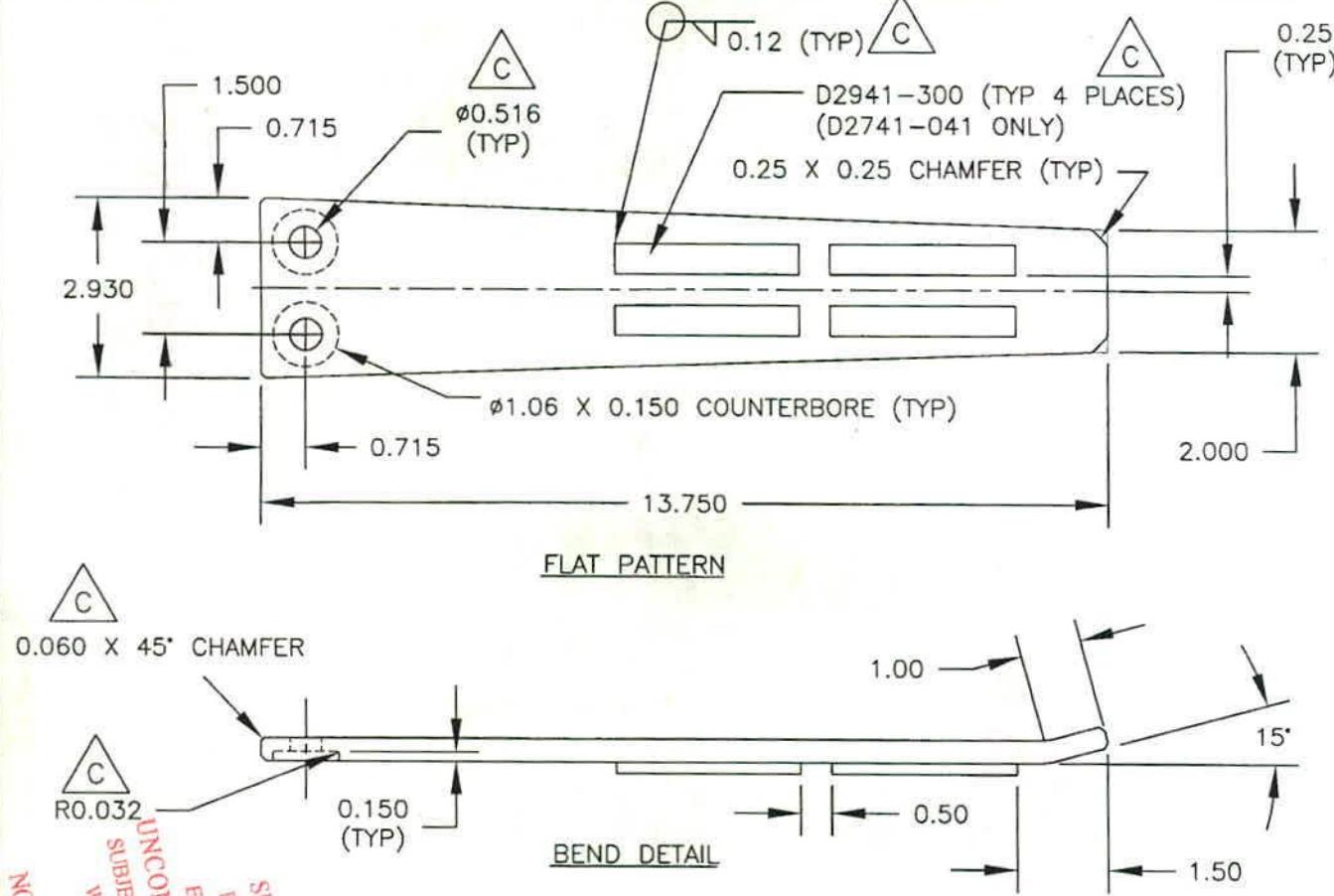
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector	
			Initial Design Mgr	Action Description Design Mgr	Sign & Date				

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

NO 2741
WORK ORDER
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE



D2741 BLADE

- 1) MATERIAL: AISI 4130 STEEL 0.375 THICK
MIN. ULTIMATE TENSILE STRENGTH = 152 ksi (34-40 HRC)
MIN. YIELD TENSILE STRENGTH = 141 ksi
- 2) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.030 TO 0.060
- 6) TO MAKE D2741-041, WELD D2941-300 (4) AS SHOWN ABOVE.
REMOVE POWDER COAT FROM SURFACE OF D2941-300
- 7) TO MAKE D2741-043, WELD 7560 HARDCOAT ROD INSTEAD OF D2941-300



RELEASED
06.02.07

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
<i>PH</i>	<i>PH</i>	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
<i>H</i>	<i>H</i>	D2741
DATE	TITLE	REV. C
06.01.12	BLADE	
A	98.04.16	NEW ISSUE
B	98.09.01	CHANGE C'SINK TO C'BORE
C	06.01.12	LARGER HOLE, ADD RADIUS AND CHAMFER ADD -041/-043 OPTIONS
	SCALE	1:3

DART AEROSPACE LTD	Work Order:	27186
Description: BLADF	Part Number:	D2741
Inspection Dwg: D2741 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by:	<i>ml</i>	Audited by:	<i>JL</i>	Prototype Approval:	<i>NIA</i>
Date:	<i>06/05/28</i>	Date:	<i>06/05/28</i>	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	



VAC AERO
INTERNATIONAL INC.

RELEASE NOTE

GST No.: R105468102

OAK 77463-1

X HEAD OFFICE
1371 SPEERS ROAD, OAKVILLE, ONTARIO
CANADA L6L 2X5
TEL: (905) 827-4171 FAX: (905) 827-7489

2009 WYECROFT ROAD, UNIT B
OAKVILLE, ONTARIO
CANADA L6J 6J4
TEL: (905) 827-7377 FAX: (905) 827-1380

QUEBEC DIVISION
7450 RUE VÉRITÉ STREET, ST. LAURENT, QUÉBEC
CANADA H4S 1C5
TEL: (514) 334-4240 FAX: (514) 334-6269

07/26/2006

MM / DD / YYYY

PAGE : 1

1DAR01
BILL TO: DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

SHIP TO : DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

K6A 1K7

K6A 1K7

DATE SHIPPED	SHIP VIA	F.O.B.
07/26/2006		ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
1678		COD

PART No.	DESCRIPTION	UOM	QTY ORD	QTY SHPD	TEST RESULTS
D2741	BLADE	EA	24	24	<p>Process Specifications:</p> <p>HARDENED PER DWG. D2741 TO 152 KSI MINIMUM</p> <p>HRC 34-40</p> <p>MATERIAL: 4130</p> <p>Procedure: 4161</p>
					<p>100% HARDNESS TESTED</p> <p>24 PCS.</p> <p>36/37 HRC</p> <p>20</p> <p>100% TESTED 24 PCS. 36/37 HRC</p>

I hereby certify that the material covered by this release note has been inspected and tested and conforms to all specifications relevant thereto in accordance with the conditions of the contract / or purchase order.

ON BEHALF OF VAC AERO INTERNATIONAL INC.

Sara Freeman
Authorized O.C. Inspector

